



Puget Sound Air Pollution Control Agency

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339

Notice of
Construction No. 3382

Date JUN 19 1981

One dry process 92 TPH (2200 TPD, 750,000 TPY) coal-fired cement plant with baghouse control at 177,000 cfm. The plant consists of the following modifications and additions (see attached): Systems 141, 151, 161, 163, 152, 155, 331, 212, 341, 351, 361, 431, 471, 461, 462, and 463 with 24 baghouses of various sizes.

NATHAN A FERNOW

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ASH GROVE CEMENT WEST INC.

3801 E MARGINAL WAY S

SEATTLE

WA 98134-1113

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R ASH GROVE CEMENT WEST INC.

3801 E MARGINAL WAY S

SEATTLE

WA 98134-1113

INSTALLATION ADDRESS

ASH GROVE CEMENT WEST INC., 3801 E MARGINAL WAY S, SEATTLE, WA, 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Air Pollution Control Agency to the applicant to install, alter or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of PSAPCA.
2. Compliance with this ORDER and its conditions does not relieve the owner or operator from the responsibility of compliance with Regulations I, II or III, RCW 70.94 or any other emission control requirements, nor from the resulting liabilities and/or legal remedies for failure to comply.
3. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
4. This source is subject to Subpart F of 40 CFR 60.
5. The emissions from the main baghouse shall not exceed the following limits:
 - a. for carbon monoxide (CO): 1000 ppm @10% oxygen, 538 pph (pounds per hour) 8-hr ave. and 2,353 tpy (tons per year);
 - b. for Nitrogen Oxides (NOx): 668 ppm @10%O₂ 1-hr, 590 pph, 422 pph (24-hr ave), 478 ppm @10%O₂-24hr, and 1846 tpy.
 - c. for Sulfur Dioxide (SO₂): 33 ppm @10%O₂-1hr, 40 pph and 176 tpy;
 - d. for Particulate Matter (PM): 10.6 pph and 46 tpy.
6. The monitoring and reporting of CO, NOx, SO₂, and Opacity shall be done in accordance with Article 12 of Regulation I.
7. Emission of particulate matter from all baghouses shall not exceed 0.010 grains/dscf.
8. All emission testing, monitoring and reporting shall be performed in accordance with PSAPCA requirements.
9. Offsets of PM emissions (deducted from ERC# 107) are required under this NC3382, pursuant to Section 6.08 of Regulation I.

ORIGINAL to:
NATE FERNOW
SEATTLE

HARRY A. WATTERS
Reviewing Engineer

HW

Anita J. Frankel
Air Pollution Control Officer

SEA0203

Ash Grove Cement West, Inc. Emission Sources
Seattle Project

Note: Conveyors are covered except where denoted by an asterisk(*).

SOURCE

DESCRIPTION	ITEM NO.	CONTROL (ITEM NO.)	AIR/CLOTH	SO. FT	ACTUAL CFM	MAKE & MODEL (FULLER #)	
<u>Transport from Existing Tower (141.)</u>							
3.4'x 102' Belt Conveyor, 900 TPH	141.030✓	Baghouse (141.040)	5.71	638	3643	49TA10	
<u>Limestone Storage (151.)</u>							
4.1 x 612' Belt Conveyor, 900 TPH	151.010✓	Spray (151.005)				4 Spraying System	
✓(3.4'x 82' Belt) Distributor/Stacker	151.020✓	Baghouse (151.015)	5.61	469	2650	Conejet(or equal)	
Bridge Type Reclaimer, 260 TPH	151.100*					36TA10	
2.2'x 493' Belt Conveyor, 260 TPH	151.200✓	Baghouse (161.015)	5.27	833	4390	64TA10	
<u>Limestone Transport (161.)</u>							
2.2'x 30' Belt Conveyor, 210 TPH	161.010✓	Baghouse (161.015)	5.27	833	4390		
2.2'x 240' Belt Conveyor, 210 TPH	161.020✓	Baghouse (161.015)+	5.27	833	4390		
		Baghouse (163.020)	5.15	1870	9630		
<u>Limestone Transport (163.)</u>							
2.75'x 51' Belt Conveyor, 440 TPH	163.010✓	Baghouse (163.020)	5.15	1870	9630	1144C10	
2.75'x 262' Belt Conveyor, 440 TPH	163.030	Baghouse (163.020)	5.15	1870	9630		
2.75'x 262' Belt Conveyor, 440 TPH	163.030	Baghouse (163.050)	4.93	833	4107	64TA10	
<u>Intake for Clay and Additives (152.)</u>							
Truck Hopper & Apron Feeder, 285 TPH	152.010	Baghouse (152.030)	5.77	1300	7501	100C10	
2.2'x 37' Belt Conveyor, 285 TPH	152.025	Baghouse (152.030)	5.77	1300	7501		
2.2'x 245' Belt Conveyor, 285 TPH	152.040	Baghouse (152.060)	5.27	833	4390		
2.2'x 41' Belt Conveyor, 285 TPH	152.050	Baghouse (152.060)	5.27	833	4390	64TA10	
2.2'x 218' Belt Conveyor, 285 TPH	152.100	Baghouse (163.020)	5.15	1870	9630	1144C10	
<u>Iron Ore/Sand to Silos (155.)</u>							
2.2'x 211' Belt Conveyor, 285 TPH	155.020	Baghouse (155.050)	4.90	1300	6370	100C10	
<u>Raw Material Silo and Mill Feed (331.)</u>							
4.4'x 10' Dosimat Belt Feeder	331.050	Baghouse (331.210)	5.38	1300	6994	100C10	
4.75'x 14' Apron Feeder	331.060	Baghouse (331.210)	5.38	1300	6994		
2.75'x 7' Dosimat Belt Feeder	331.120	Baghouse (331.210)	5.38	1300	6994		
2.75'x 7' Dosimat Belt Feeder	331.140	Baghouse (331.210)	5.38	1300	6994		
2.2'x 119' Belt Conveyor, 195 TPH	331.170	Baghouse (331.220)	5.20	1300	6760	100C10	
2.2'x 163' Belt conveyor, 195 TPH	331.190	Baghouse (331.330)	4.86	469	2279	36TA10	
2.2'x 163' Belt conveyor, 195 TPH	331.190	Baghouse (341.180)	5.65	469	2181	36TA10	

SOURCE

DESCRIPTION	ITEM NO.	CONTROL (ITEM NO.)	AIR/CLOTH	SO. FT	ACTUAL CFM	MAKE & MODEL (FULLER #)
<u>Intake for Coal (212.)</u>						
5.5'x 28' Apron Feeder, 235 TPH	212.020✓	Baghouse (212.040)	5.08	1560	7925	120C10 36TA10 25TA10
2.7'x 44' Belt Conveyor, 235 TPH	212.030✓	Baghouse (212.040)	5.08	1560	7925	
2.7'x 483' Belt Conveyor, 235 TPH	212.050	Baghouse (212.060)	5.59	469	2622	
2.7'x 133' Belt Conveyor, 235 TPH	212.070	Baghouse (212.080)	4.56	326	1487	
<u>Raw Mill (341.)</u>						
Vertical Roller Mill, 200 TPH	341.020✓	Baghouse (342.030)	1.40	113090	158325	211M11309
<u>Raw meal Transport (351.)</u>						
1.3'x 1.1'x 82' Fluxoslide, 185 TPH	351.020✓	Baghouse (361.350)	4.55	638	2903	49TA10
Air Lift, Pneumatic Conveyor	351.050✓	Baghouse (351.090)	5.03	1560	7847	120C10
<u>Blending System (361.)</u>						
Silo Air, Used for Mixing	✓	Baghouse (361.300)	5.20	1042	5418	80C10
2.7'Dia. x 160' Screw Conveyor	361.140	Baghouse (361.350)	4.54	638	2897	49TA10
1.3'x 1.1'x 10' Fluxoslide, 165 TPH	361.160	Baghouse (361.350)	4.54	638	2897	
Bucket Elevator, 165 TPH	361.170✓	Baghouse (361.350)	4.54	638	2897	
Air Lift, Pneumatic Conveyor	361.200✓	Preheater See 421.				
<u>Preheater (421.) & Kiln (431.)</u>						
5 Stage Preheater/Precalciner Kiln	421.100✓	Baghouse (342.030)	1.46	113090	166000 (Coal)	211M11309
Including Satellite Coolers, 92 TPH	431.010,140		1.56	113090	177000 (Gas)	
<u>Clinker Conveying (471.)</u>						
Deep Drawn Pan Conveyor, 92 TPH	471.020✓	Baghouse (471.070)	5.02	638	3202	49TA10
G-Cooler, Heat Exchanger	471.100✓	Baghouse (471.070)	5.02	638	3202	
2.2'x 119' Belt Conveyor	471.170	Baghouse (Existing)				
<u>Raw Coal Bin and Feed (461.)</u>						
2.7'x 11' Dosimat Belt Feeder, 7 TPH	461.020✓	Baghouse (461.060)	4.08	638	2603	49TA10
2.7'x 11' Dosimat Belt Feeder, 7 TPH	461.030✓	Baghouse (461.070)	4.08	638	2603	49TA10
<u>Coal Mill (462.)</u>						
Coal Mill, Bowl Mill (2)✓	462.060	Baghouse (462.120)	3.95	2550	10073	196C10
<u>Firing Equipment (463.)</u>						
Coal Bin, Storage Silo	463.100✓	Baghouse (463.110)	4.08	208	848	16AT10